

**Work Order ID 69955**

Wednesday, May 25, 2011 7:46:54 AM



Page 1

Item ID: DSK076

Accept



Setup Start



Revision ID:

Stop



Item Name: D2891-1 TURNING DETAIL

Start Date: 5/25/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 5/31/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 11-05-25 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr -

DSK076

Rev A

100

0.00



DOOSAN LATHE

Doosan

Memo

0.00

Doosan Lathe

Turn blank for as per Folio FA046

11-5-31

10

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

11-5-31

10

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

11/5/31

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 69955**

Wednesday, May 25, 2011 7:46:54 AM



Page 2

Item ID: DSK076

Accept



Setup Start



Revision ID:

Stop



Item Name: D2891-1 TURNING DETAIL

Start Date: 5/25/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 5/31/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

0.00



Packaging

PT 11-5-31

P

Packaging

Memo

0.00

Packaging

Identify and Stock in Kanban Location: CNC

140

0.00



QC21- Final Inspection - Work Order Release

QC

Memo

0.00

Quality Control

w/c h d

MF  
11-06-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, May 25, 2011 7:46:44 AM

Page 1

Work Order ID: 69955



Parent Item: DSK076

Parent Item Name: D2891-1 TURNING DETAIL

Start Date: 5/25/2011

Required Date: 5/31/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP rev A. 08.03.13 new issue EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D6104-003

Manufactured No

Each

21.0000

10



11.5.31

Round Billet, 17-4

Location

Loc Qty

Loc Code

MAT043

21

60943

3

66960

2

68174 ✓

16

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	
<b>Description:</b> Turning Detail for D2891-1		<b>Part Number:</b>	<b>DSK076</b>
<b>Inspection Dwg:</b> DSK076	<b>Rev:</b> A	<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
Lathe Section								
A	2.274	2.279		2.278	2.278	2.278	2.278	2.278
B	3.702	3.722	2.02	3.711	3.711	3.711	3.711	3.711
C	2.564	2.584		2.574	2.574	2.574	2.574	2.574
D	0.718	0.738		.728	.728	.728	.728	.728
E	0.090	0.110		.099	.099	.099	.099	.099
F	2.464	2.484		2.472	2.472	2.472	2.472	2.472
G	2.029	2.049		2.039	2.039	2.039	2.039	2.039
H	2.964	2.984		2.974	2.974	2.974	2.974	2.974
I	0.913	0.933		.920	.920	.920	.920	.920
J	0.022	0.042		.032	.032	.032	.032	.032
K	0.090	0.110		.099	.099	.099	.099	.099
L								
M								
N								
O								
P								

<b>Measured by:</b> <i>RD</i>	<b>Date:</b> 11.5.31
<b>Audited by:</b> <i>SA</i>	<b>Date:</b> 11/5/31
<b>Prototype Approval:</b>	<b>Date:</b>

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	<i>[Signature]</i>





<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	69955
<b>Description:</b> Turning Detail for D2891-1		<b>Part Number:</b>	DSK076
<b>Inspection Dwg:</b> DSK076	<b>Rev:</b> A	<b>Page 1 of 1</b>	

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J	0.022	0.042		.032	.032	.032	.032	.032
K	0.090	0.110						
L								
M								
N								
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<b>Measured by:</b> [Signature]	<b>Date:</b> 11.5.31
<b>Audited by:</b> [Signature]	<b>Date:</b> 11.5.31
<b>Prototype Approval:</b>	<b>Date:</b>

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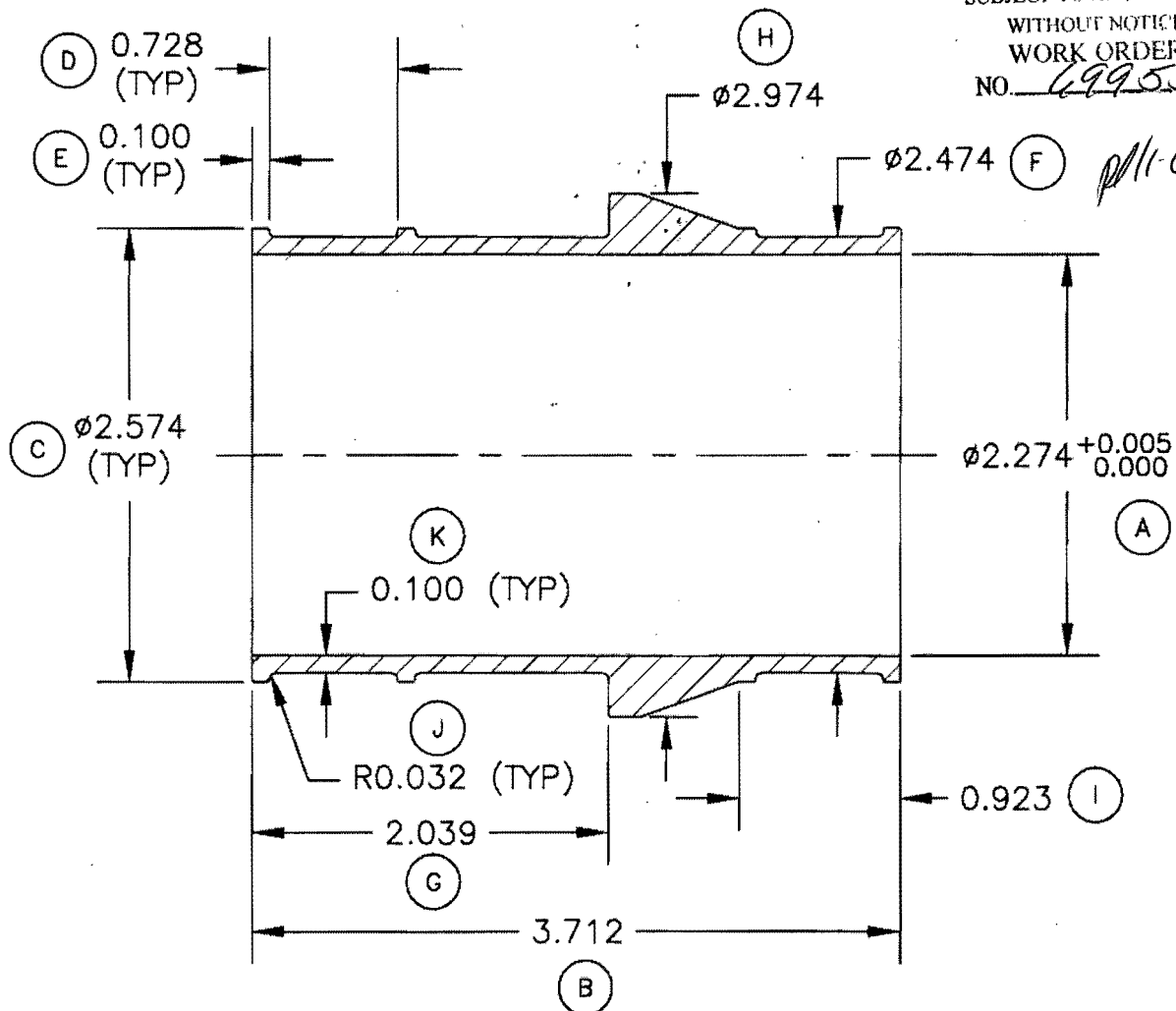
**NOTE:** Date & initial all entries



DESIGN RT	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. DSK 076	REV. A SHEET 1 OF 1
DATE 03.05.20		TITLE TURNING DETAIL FOR D2891-1	SCALE 1:1
A	03.05.20	NEW ISSUE	

RELEASED  
03.07.01 [Signature]

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 69955



D2891-1 TURNING DETAIL

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